

Work Order ID 103379

June-24-13 10:31:00 AM

Shp 26/06

103379

Page 1

Item ID: E4662-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Pilot Panel

Start Date: 6/24/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/25/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

E4662

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2- Deburr if necessary

0 EL 13-6-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

0 EL 13-6-24

Work Order ID 103379

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Page 2

June-24-13 10:31:00 AM

Item ID: E4662-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Pilot Panel

Start Date: 6/24/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/25/13

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

Work Order ID 103379

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Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Pilot Panel

Start Date: 6/24/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/25/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>51</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

u 130626

MC5 130626

u 130626

Picklist Print

June-24-13 10:31:00 AM

Page 1

Work Order ID: 103379

Parent Item: E4662-3

Parent Item Name: Pilot Panel

Start Date: 6/24/13

Required Date: 6/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.06.04 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	157.0094	2.3344	2.4572632			

Location

Loc Qty

Loc Code

MAT021

157.0093578

121473

0.9161578

123279

72.89

125257

51.2032

M126075

32

M2024T35-125

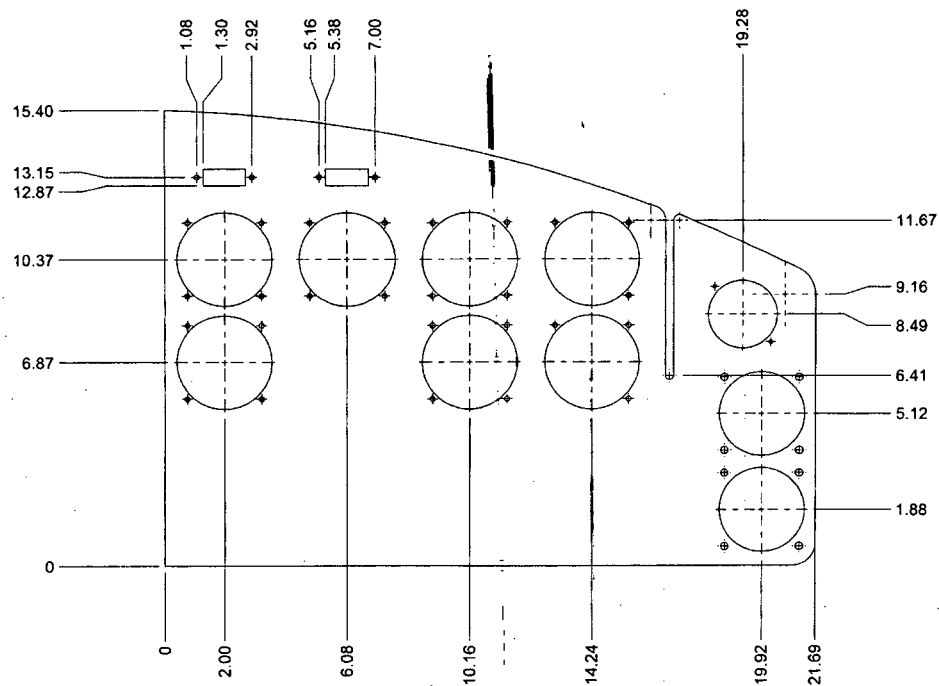
M123076

X

2.63

R 13-6-24

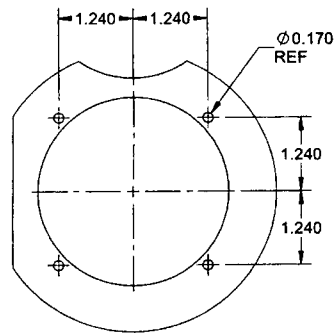
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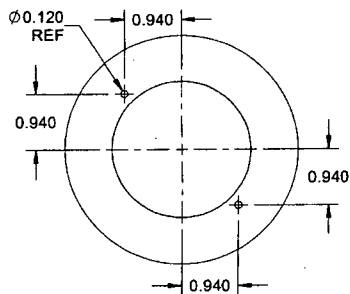
E4662-3 PILOT PANEL
AUXILIARY VIEW

RELEASED
2012-05-01
ND

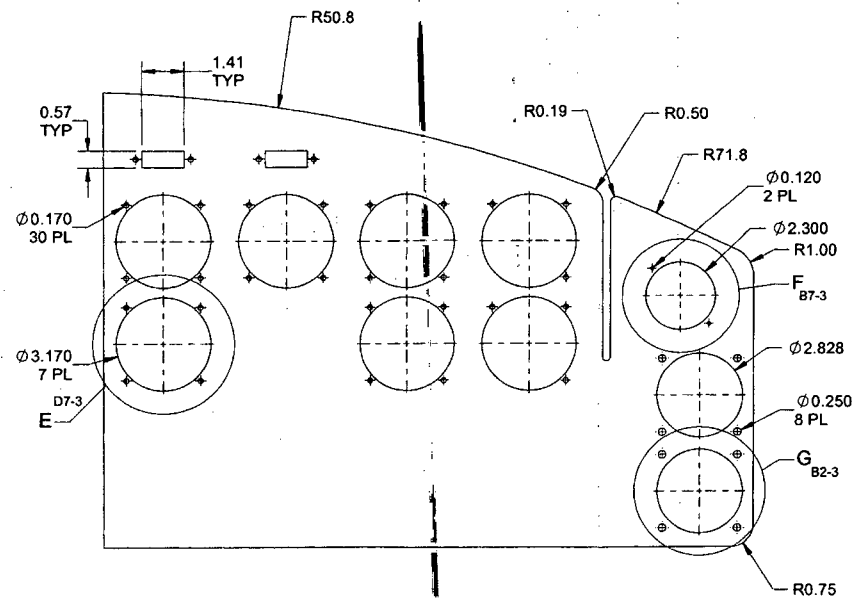
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	INSTRUMENT PANEL	NTS
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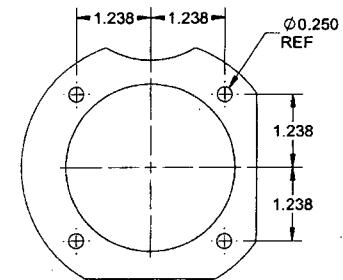
DETAIL E
C5-3



DETAIL F
C3-3



E4662-3 PILOT PANEL



DETAIL G
B3-3

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.125
OR
6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 2.63 lbs

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RELEASED
2012-06-01

DART AEROSPACE LTD	Work Order: 103379
Description: PILOT PANEL	Part Number: E4662-3
Inspection Dwg: E4662 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.170 x30	+0.05/-0.001	0.171	✓		✓ Skm01	
Ø 3.170 x7		3.17	✓		"	
0.57		0.57	✓		"	
1.41		1.412	✓		"	
Ø 0.250 x8		0.25	✓		"	
2.828		2.828	✓		"	
2		2	✓		"	
6.08		6.08	✓		"	
10.16		10.16	✓		"	
14.24		14.24	✓		T Skm06	
17.28		17.28	✓		"	
19.92		19.92	✓		"	
21.67		21.69	✓		"	
1.88		1.88	✓		"	
5.12		5.12	✓		"	
12.87		12.87	✓		"	
6.87		6.87	✓		"	
10.37		10.37	✓		"	
12.87		12.87	✓		"	
13.15		13.15	✓		"	
14.4		14.4	✓		"	
0.125		0.126	✓		✓ Skm01	

Measured by: EL	Audited by: 27	Preliminary Approval:
Date: 12-6-24	Date: 13-6-25	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15